

Work Order ID 62951

Thursday, October 14, 2010 12:35:11 PM

Page 1

Item ID: D2564

Accept

Revision ID:

Item Name: Mounting Angle

Start Date: 10/14/2010 Start Qty: 20.00

Required Date: 10/22/2010 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2564

Rev B1

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

~~A~~ 10/11/15

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA276 Rev: _____ & Dwg D2564 Rev: _____
2-Deburr if necessary

conventional milling

~~A~~ 10/11/15

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

~~A~~ 10/11/15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 62951

Thursday, October 14, 2010 12:35:11 PM

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Item ID: D2564

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Angle

Start Date: 10/14/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 20.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130  QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | | | 20 | 0 | | |
| 140  Packaging Packaging | Identify as per dwg & Stock Location: <u>NA</u> Memo *** STOCK IN STEP CELL*** | 0.00 0.00 | | | | 20 | 0 | | |
| 150  QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

mf
10-11-15

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, October 14, 2010 12:35:16 PM

Page 1

Work Order ID: 62951



Parent Item: D2564

Parent Item Name: Mounting Angle

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: ☐D☐02.09.09☐Re-format; Added FA276 Folio☐KJ/RF

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6207 | | Manufactured | No | | | 100 | f | 11.6010 | 0.0916 | 1.928421 | | | |



Angle Extrusion



Location

Loc Qty

Loc Code

MAT07

11.601

46909

11.601

M 6061 76 A 1.00x.125 M 115688

2. ft # 10/11/15

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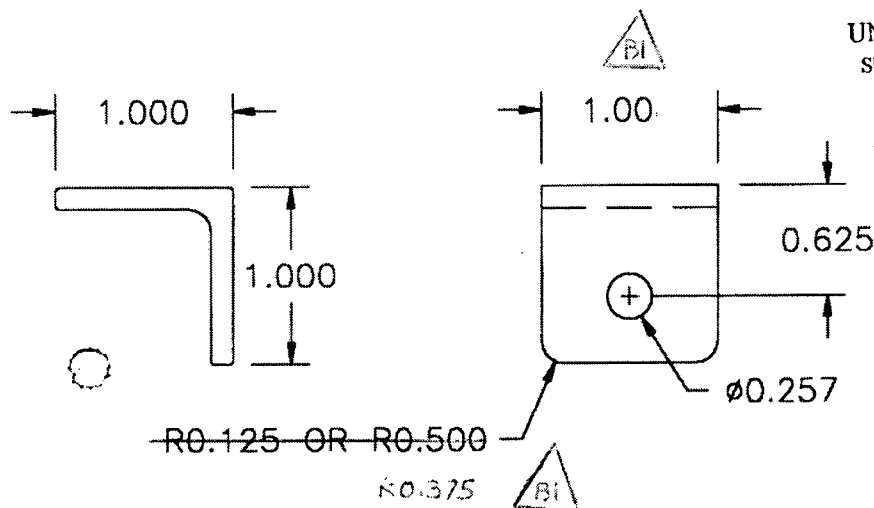
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NOTE: Date & initial all entries



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|------------------|----------|-------------------------|--|--|--------------|
| DESIGN | | DRAWN BY | | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| MIKE M | | MIKE M | | DRAWING NO. D2564 | REV. B |
| CHECKED BW | | APPROVED BW | | | SHEET 1 OF 1 |
| DATE 96:04:30 | | TITLE MOUNTING ANGLE | | | SCALE 1:1 |
| B | 97:05:06 | | MODIFIED DIMENSIONS | | |
| BI | 02.07.17 | | R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000 | | |

RELEASED
97/05/06 BW



SHOW COPY
REVISION
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITH NO. 6-2951
WORK ORDER
NO. 6-2951
2/10-10-14

NOTES

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 - 0.015
- 3) TOLERANCES PER DART 651 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES.

Dart Aerospace Ltd

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